



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7501
Job Sheet 178038



Part No: 647.7501

Job Qty: 2 ea

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/25/18

Job Tracking No:

Due Date: 6/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		6/4/18	0.00	0.00	Start Up Stores/Pkg-1		MAY 30 2018
110	Packaging	2 pcs		6/4/18	0.00	0.00	Packaging1-1		MAY 30 2018
120	Small Fab	2 pcs		6/4/18	0.00	2.56	Small Fab-1		
130	QC	2 pcs		6/4/18	0.00	0.00	QC5		
140	Packaging	2 pcs		6/4/18	0.00	0.00	Packaging3-1		
150	QC21-SA	2 Ea		6/4/18	0.00	0.00	QC21		JUN 04 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

Descriptions: 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	S068686
647.7601	Lower Deflector Assembly	1 2 Ea (1 ea)	90-Start up Operation	S04445
647.7810	Bracket A	1 2 Ea (1 ea)	90-Start up Operation	S047608X1
647.7811	Bracket B	1 2 Ea (1 ea)	90-Start up Operation	S047632X1
647.7813	Center Plate, Lower	1 2 Ea (1 ea)	90-Start up Operation	S027807
647.7814	Fwd Bracket	1 2 Ea (1 ea)	90-Start up Operation	S030228
647.7815	Fwd Bracket	1 2 Ea (1 ea)	90-Start up Operation	S030228
647.7816	Aft Bracket	1 2 Ea (1 ea)	90-Start up Operation	S030228
647.7817	Aft Bracket	1 2 Ea (1 ea)	90-Start up Operation	S030228
MS21042-08	Use MS21042L08	13 26 Ea (13 ea)	90-Start up Operation	S044234
MS21042-08	Nut use MS21042L3	3 6 Ea (3 ea)	90-Start up Operation	S075328
MS27039-08-19	Screw	7 14 Ea (7 ea)	90-Start up Operation	S044235
MS27039-08-24	Screw (MS27039-0824)	6 12 Ea (6 ea)	90-Start up Operation	S034100
MS27039-1-19	Screw	3 6 Ea (3 ea)	90-Start up Operation	S065263
NAS1149F0332P	Washer	6 12 Ea (6 ea)	90-Start up Operation	S068663
NAS1149FN832P	Washer	2 52 Ea (26 ea)	90-Start up Operation	S020601

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	4	12	0
	647.7601	2	4	0
	647.7810	2	1	0
	647.7811	2	5	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
				Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing inish Misread Turning Sequence	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐			
OTHER : _____		Misaligned/off center ☐			



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647.7813	2	4	0
647.7814	2	3	0
647.7815	2	4	0
647.7816	2	4	0
647.7817	2	3	0
MS21042-08	26	0	0
MS21042-3	6	112	0
MS27039-08-19	14	1,299	0
MS27039-08-24	12	130	0
MS27039-1-19	6	550	0
NAS1149F0332P	12	3,346	0
NAS1149FN832P	52	1,959	0

Part Specifications

Specifications could not be found.

Plex 5/25/18 10:31 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003512	S076128	646.3015	Blade	s068686	CCK102	2
003512	S076127	647.7601	Lower Deflector Assembly	s044445	CCK065	1
003512	S047608	647.7810	Bracket A	S047607	CCK077A	1
003512	S047653	647.7811	Bracket B	S047652	CCK077A	1
003512	S076125	647.7813	Center Plate, Lower	s029869	CCK114	1
003512	S076124	647.7814	Fwd Bracket	s030228	CCK114	1
003512	S076123	647.7815	Fwd Bracket	s030863	CCK114	1
003512	S076122	647.7816	Aft Bracket	s030948	CCK114	1
003512	S076121	647.7817	Aft Bracket	s031346	CCK114	1
003512	S076120	MS21042L08	Nut	s044234	ST303	13
003512	S076119	MS21042L3	Nut	s075328	ST303	3
003512	S076118	MS27039-08-19	Screw	s044235	ST277	7
003512	S076116	MS27039-08-24	Screw (MS27039-0824)	s054100	ST277	6
003512	S076114	MS27039-1-19	Screw	s065263	ST280	3
003512	S076112	NAS1149F0332P	Washer	s068663	ST262	6
003512	S076110	NAS1149FN832P	Washer	s020604	ST263	26

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/30/18 8:22 AM dart.quirion.sonia